

FIG. 1

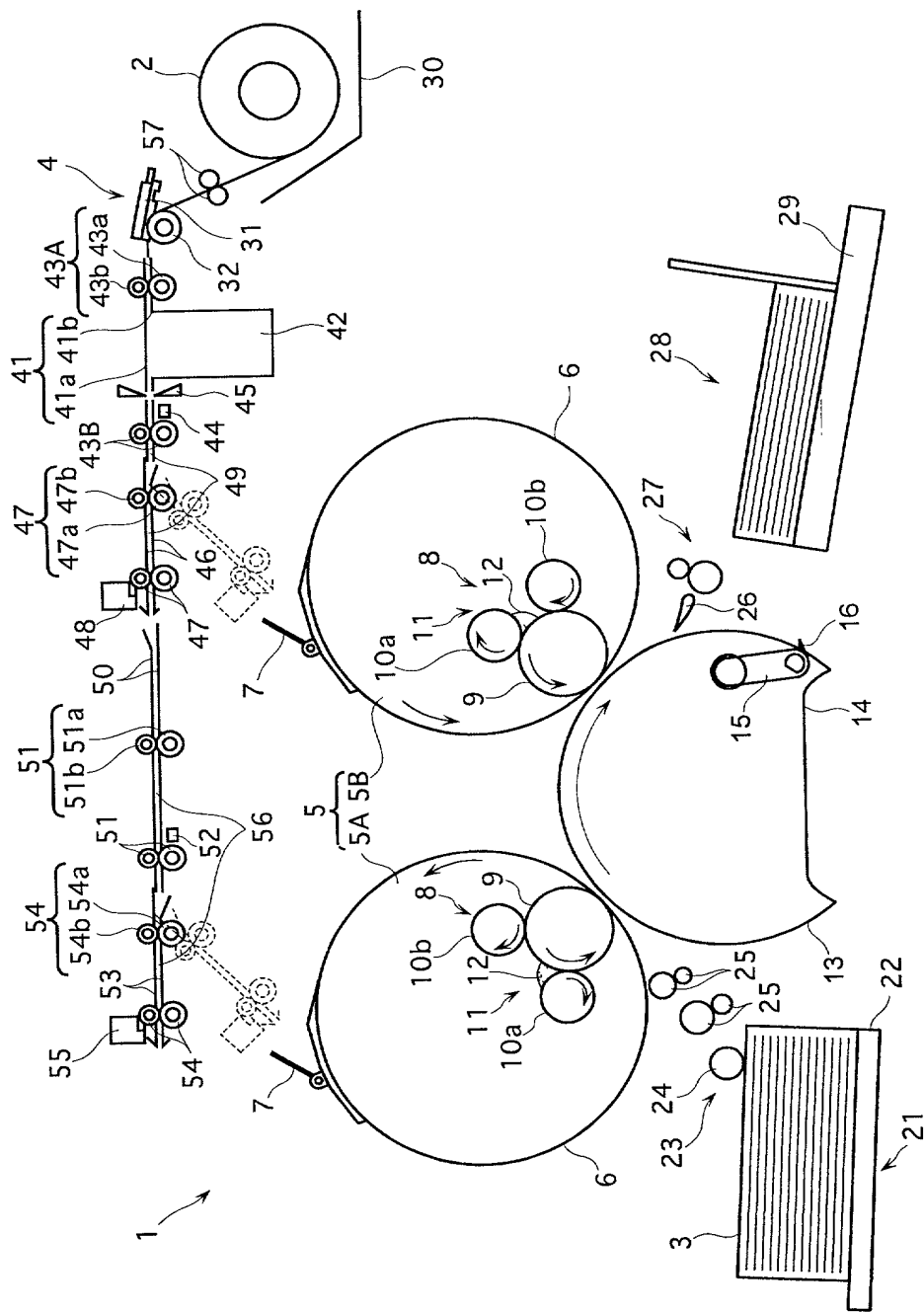
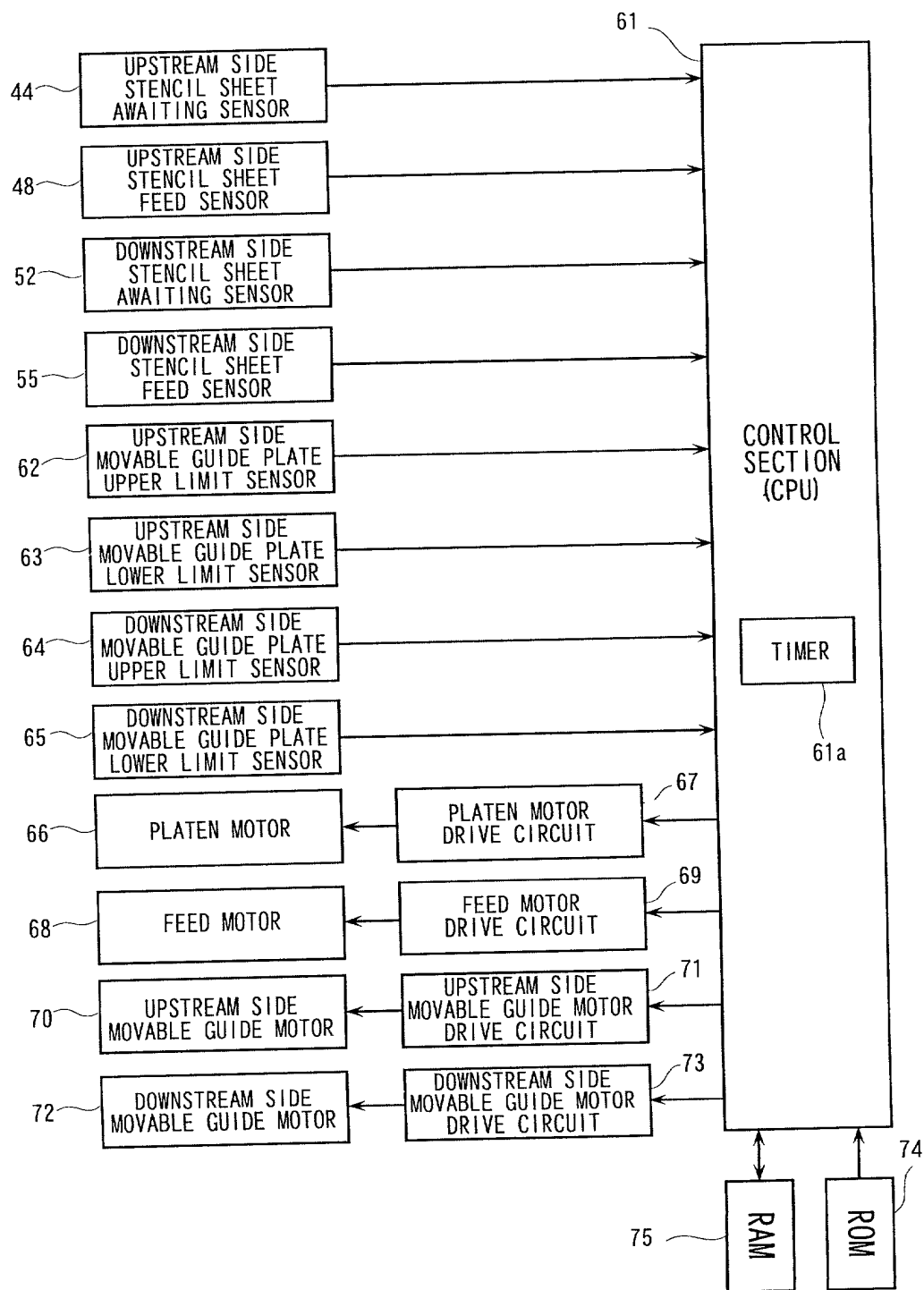


FIG.2



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FIG.3

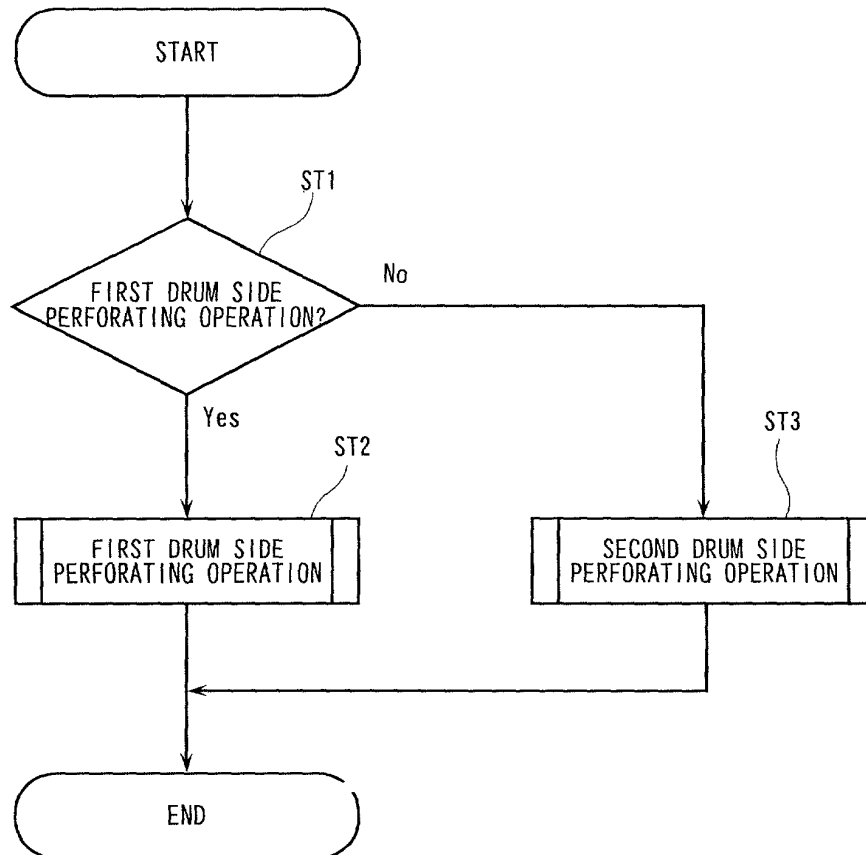
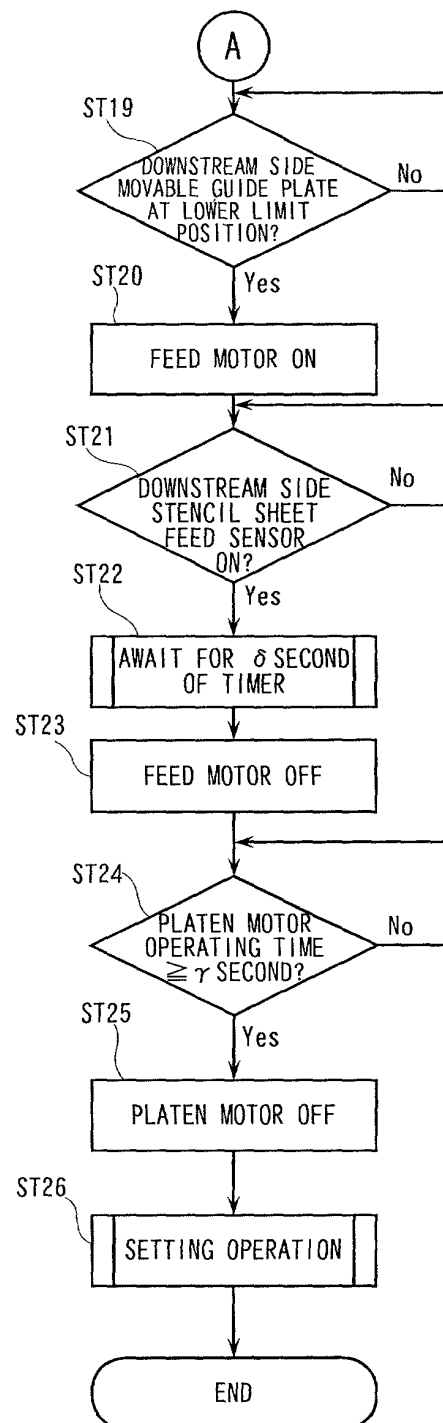
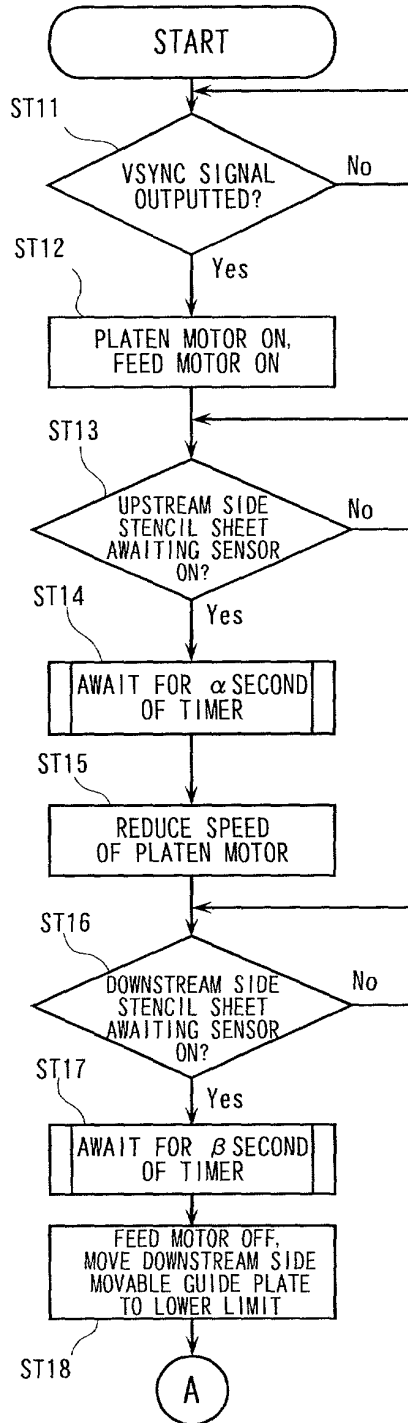


FIG.4

(FIRST DRUM SIDE PERFORATING OPERATION)



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FIG.5

(SECOND DRUM SIDE PERFORATING OPERATION)

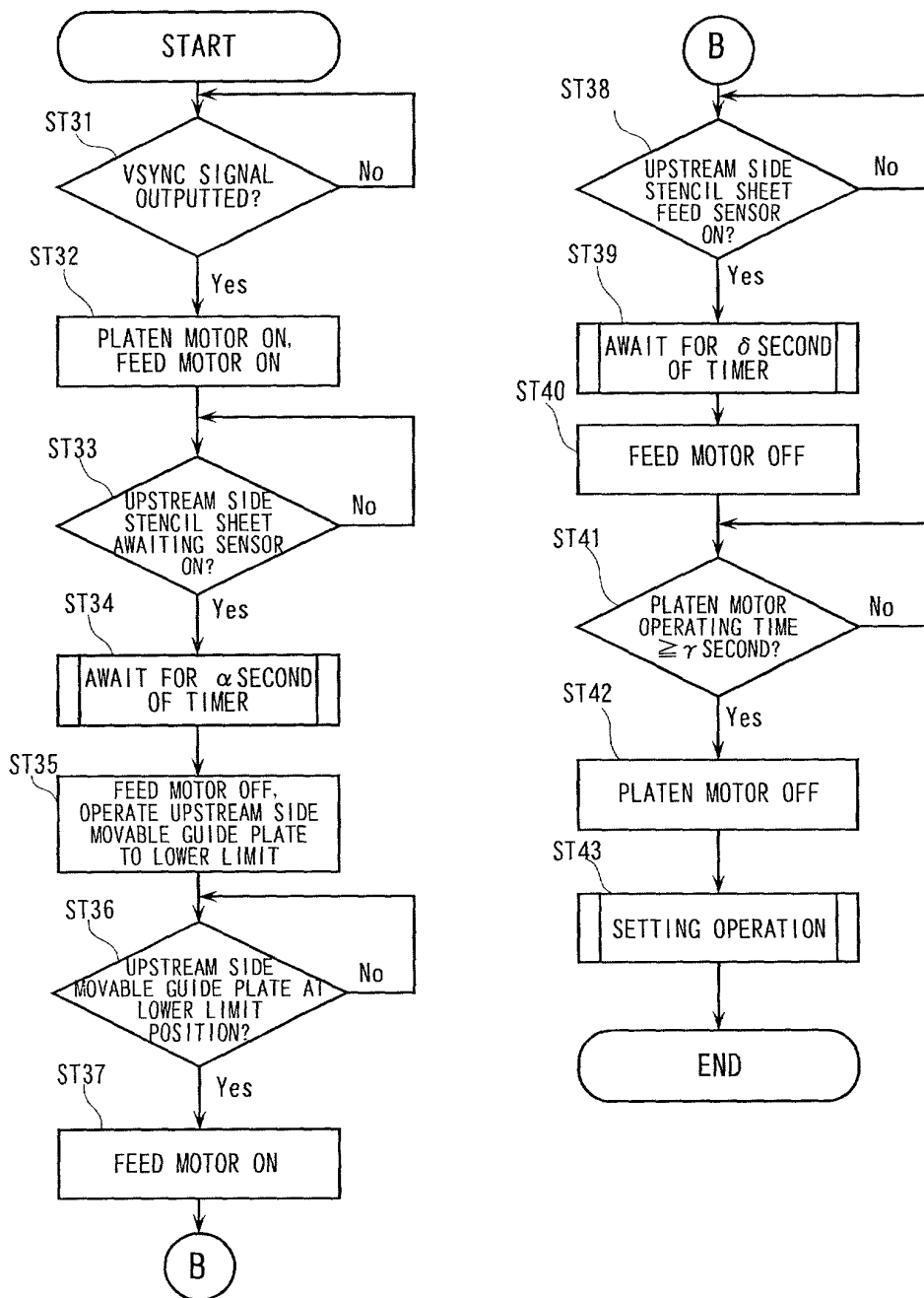
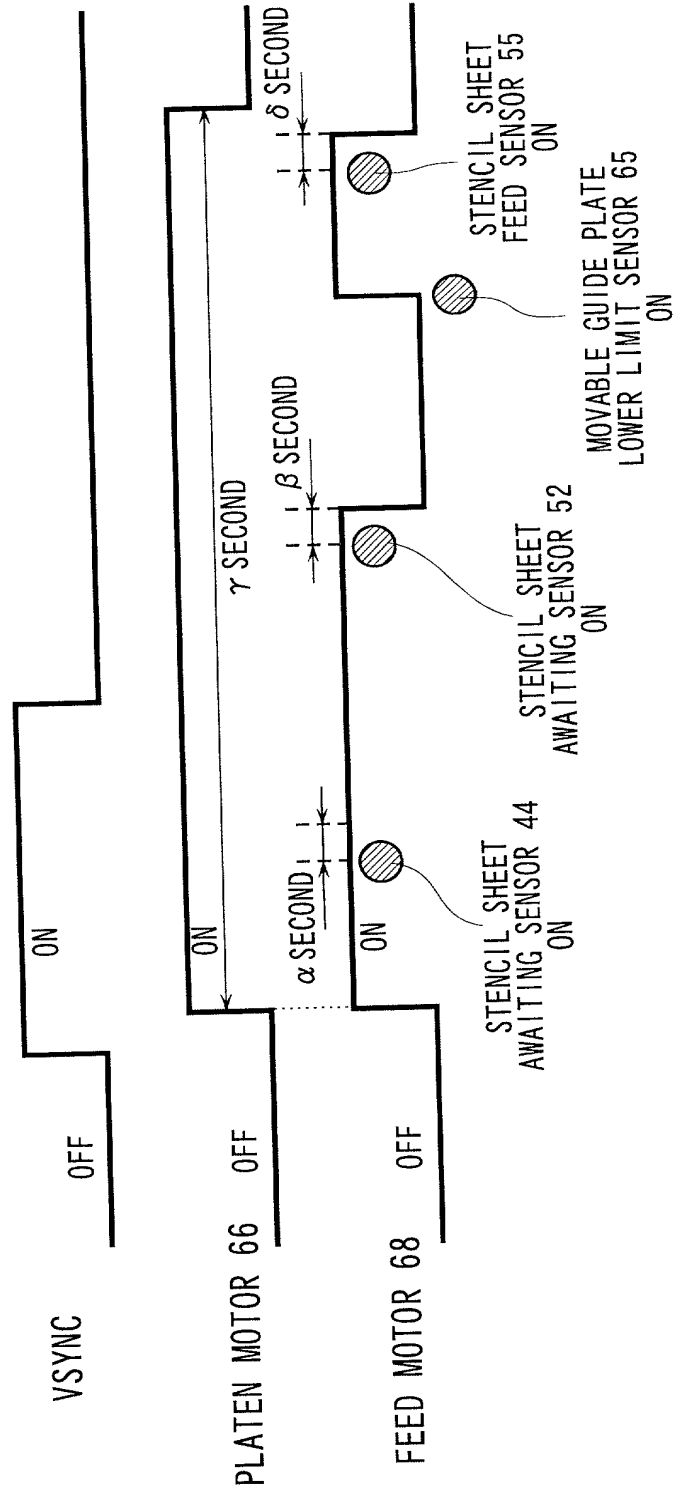
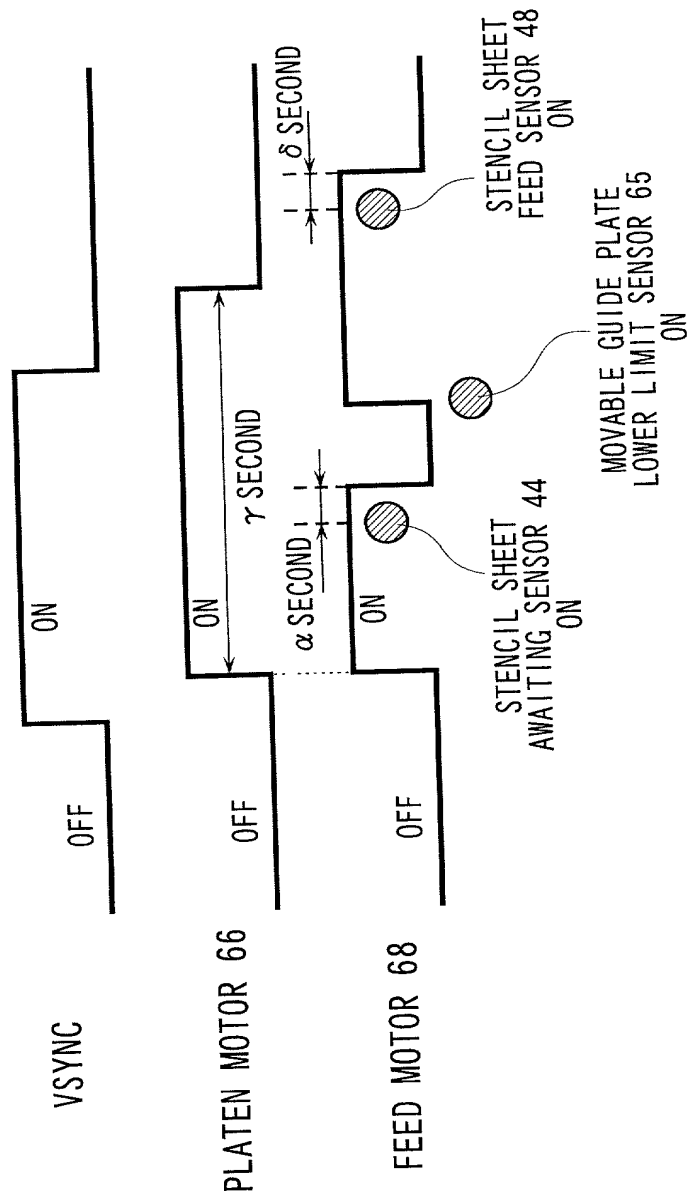


FIG.6A



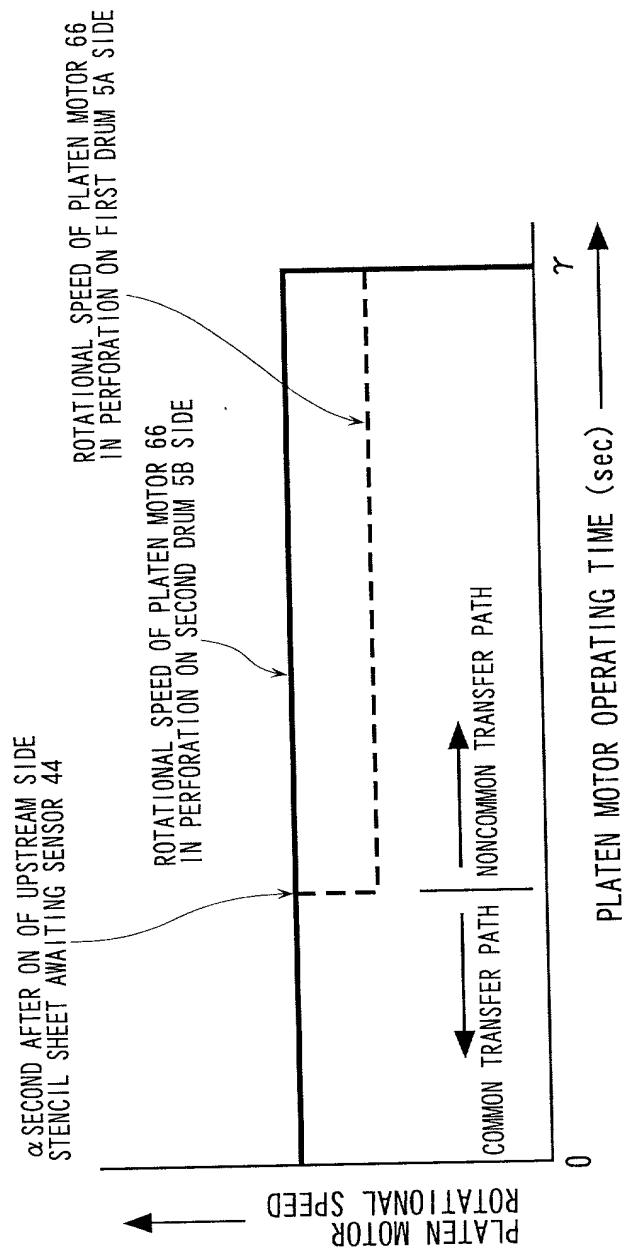
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FIG. 6B



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FIG.7

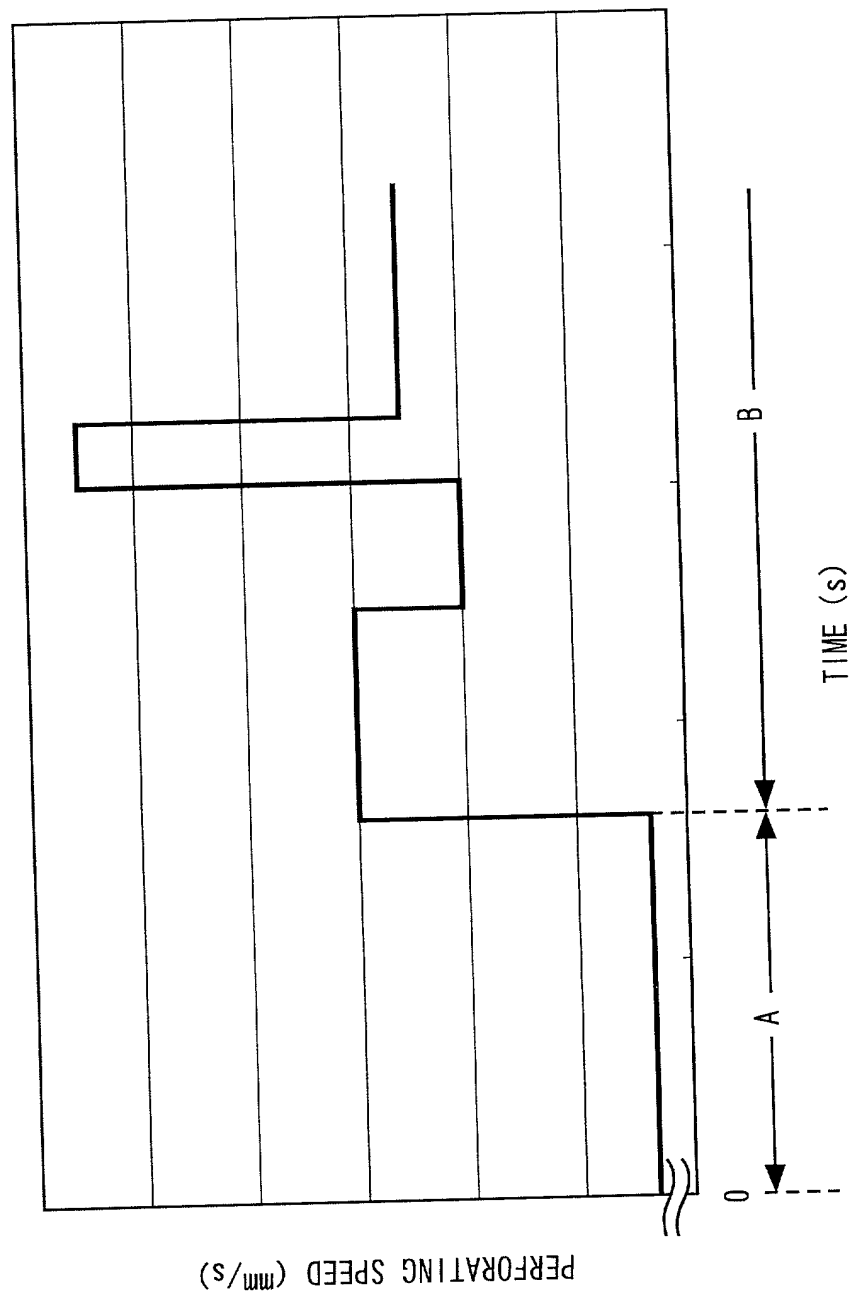


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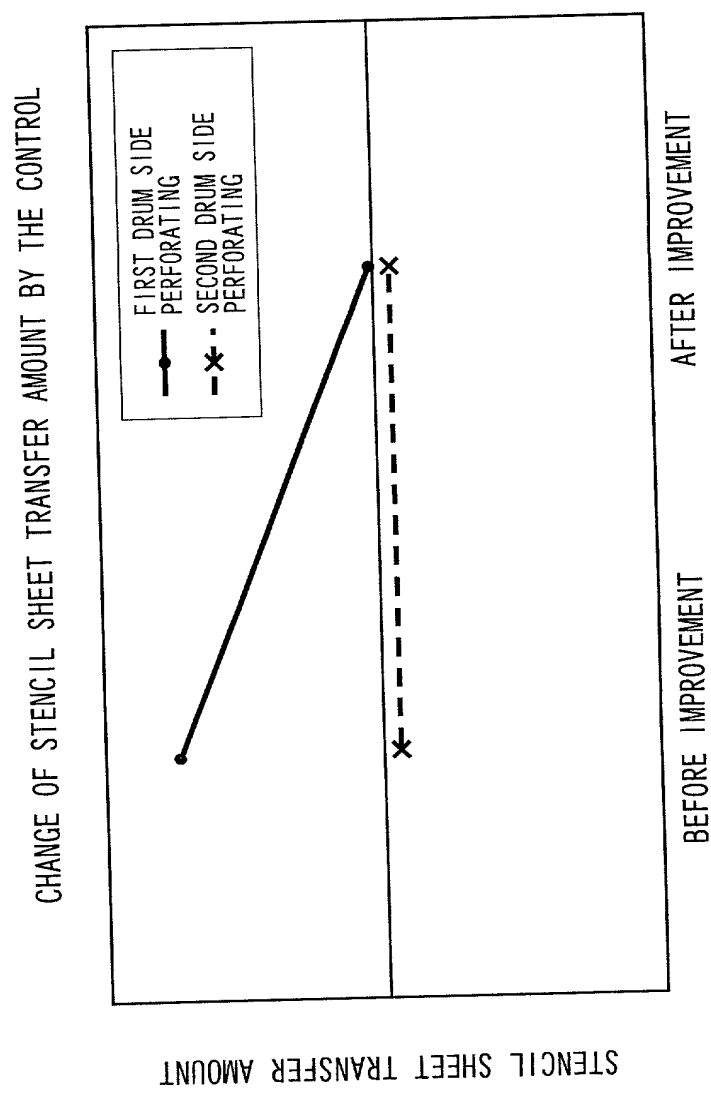
FIG.8

PERFORATING SPEED BEFORE IMPROVEMENT



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FIG.9



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FIG. 10

